Work Order ID 63389

Thursday, October 28, 2010 10:51:33 AM

Item ID: D3282-041 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Float Web (206L/407)

Start Date: 10/28/2010 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 11/12/2010 **Req'd Qty:** 4.00 **Customer:**

Reference:

Approvals: **Process Plan:** M **Date:** 101028 **Tooling:** **Date:** **Run Start** **Stop**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D3282 / Rev C									
100	Skidtubes	0.00				4	0		
Skidtubes	**Memo**	0.00							
Skidtubes	1-Cut to length as per Dwg D3282. 2- inspect for surface damage as per QSI0018 3- Deburr	DP 10-10-28							
110	HAAS CNC VERTICAL MACHINING #1	0.00				4	0		
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA579 & Dwg D3282 2-Deburr	SA 10/11/10							
120	QC2- Inspect parts off machine FAI/FAIB	0.00				4	0		
QC	**Memo**	0.00							
Quality Control		SA 10/11/10							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 63389

Thursday, October 28, 2010 10:51:33 AM

Item ID: D3282-041 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Float Web (206L/407)

Start Date: 10/28/2010 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 11/12/2010 **Req'd Qty:** 4.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				4	0		
QC	**Memo**	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00				4			
HandFinish	**Memo**	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00				4			
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 63389

Thursday, October 28, 2010 10:51:33 AM

Item ID: D3282-041 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Float Web (206L/407)

Start Date: 10/28/2010 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 11/12/2010 **Req'd Qty:** 4.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00				4	0		BE 10/11/16
Skidtubes	**Memo**	0.00							
Skidtubes	1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web A/RN/ALPS-3 104929								
170	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: LG	0.00				XY			JB 10/11/16
Packaging	**Memo**	0.00							
Packaging									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 63389

Thursday, October 28, 2010 10:51:33 AM

Item ID: D3282-041 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Float Web (206L/407)

Start Date: 10/28/2010 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 11/12/2010 **Req'd Qty:** 4.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

10/11/16 MF

10-11-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:51:37 AM

Work Order ID: 63389

Parent Item: D3282-041

Parent Item Name: Float Web (206L/407)

Start Date: 10/28/2010 **Required Date:** 11/12/2010

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP Rev:B□05.09.23□Procedure change□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20470AD4-7		Purchased	No			100	Each	2,309.000	57	228			
Rivet, Universal Head													
				Location			**Loc Qty**	**Loc Code**					
				ST320			2309						
					112492		1009			24			
					115996		1300						
D2792-130		Manufactured	No			160	Each	56.0000	1	4			
EXTRUSION													
				Location			**Loc Qty**	**Loc Code**					
				MAT06			56						
					61630		56						
D3283-1		Manufactured	No			160	Each	57.0000	2	8			
Doubler													
				Location			**Loc Qty**	**Loc Code**					
				ST046			53						
					60203		25						
					62966		28			8			
				ST048			4						
					57725		4						

BE 10/11/16

10-10-28

SAD 10-11-15

BE 10/11/16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	63389
Description: Float Web	Part Number:	D3282-041
Inspection Dwg: D3282 **Rev:** C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.62	✓		Tape	SA-1
1.500	+/-0.010	1.500	✓		Vern	SA-9
3.000	+/-0.010	3.000	✓			
6.000	+/-0.010	6.000	✓			
1.250	+/-0.010	1.250	✓		Vern	
30.000	+/-0.010	30.00	✓		Tape	
1.500	+/-0.010	1.500	✓		Vern	
72.01	+/-0.030	72.01	✓		Tape	
61.75	+/-0.030	61.75	✓			
57.50	+/-0.030	57.50	✓			
49.19	+/-0.030	49.19	✓			
43.94	+/-0.030	43.94	✓			
39.69	+/-0.030	39.69	✓			
26.68	+/-0.030	26.68	✓			
0.55	+/-0.030	.551	✓		Vern	SA-9
1.970	+/-0.010	1.971	✓			
2.38	+/-0.030	2.381	✓			
0.05	+/-0.030	.050	✓			

Measured by:		Audited by:	B.A	Prototype Approval:	N/A
Date:	10/11/07	Date:	10/11/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	

Dart Aerospace Ltd

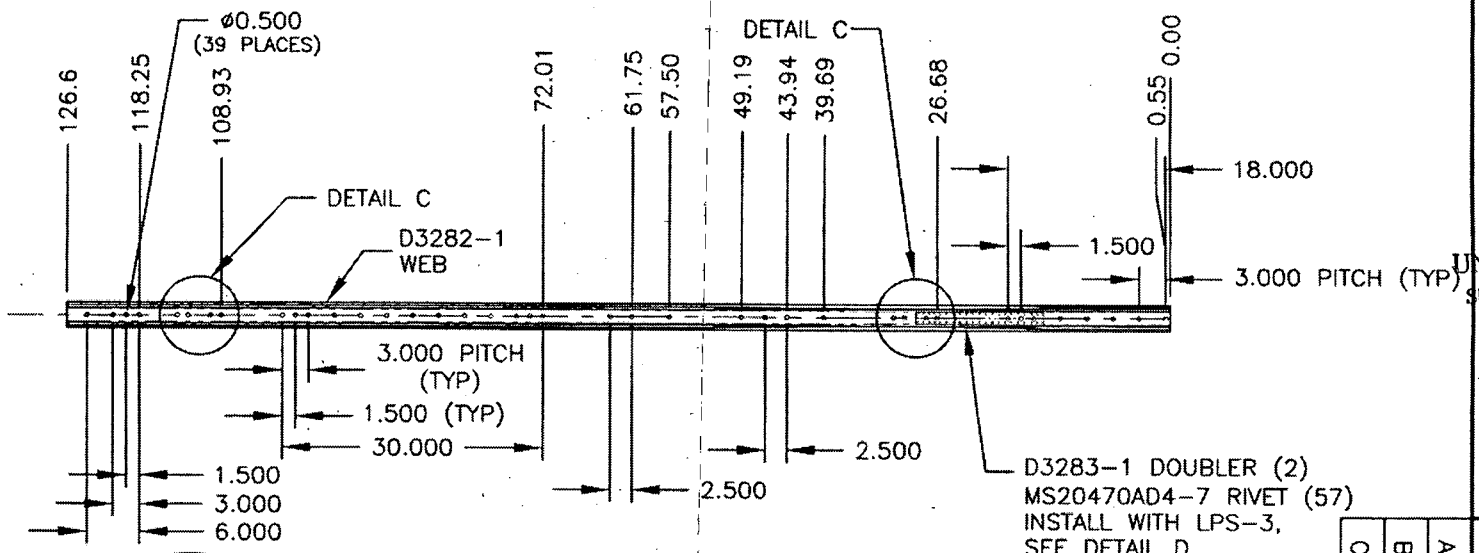
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

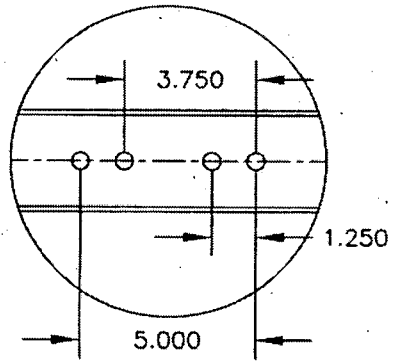
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

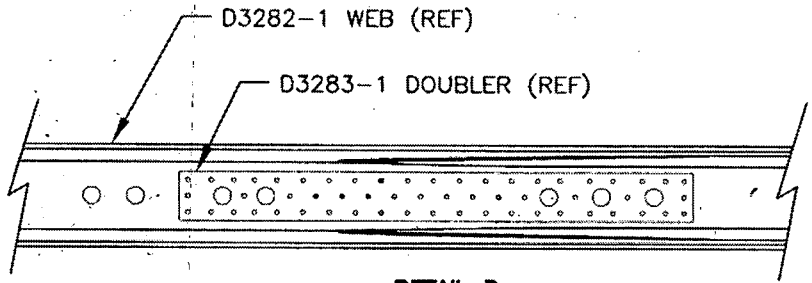
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries





DETAIL C
SCALE 1:5
RIVET HOLES NOT SHOWN
FOR CLARITY



DETAIL D
SCALE 1:5

RELEASED
05.04.12

D3282-041 FLOAT WEB

1) MAKE FROM D2792-130 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) BREAK ALL SHARP EDGES 0.010 TO 0.020
5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
6) SEE PAGE 2 FOR MACHINING DETAILS

C	05.08.09	REMOVE D3390-1, NOW MACHINED	
B	05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS	
A	04.05.05	NEW ISSUE	

DESIGN CP | DRAWN BY CP | CHECKED | APPROVED | DATE 05.08.09

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. D3282 | REV. C

TITLE FLOAT WEB, 206L/407

SCALE 1:20 | SHEET 1 OF 2

SHOP COPY
RETURN TO ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63389
10-10-26

Copyright © 2004 by DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

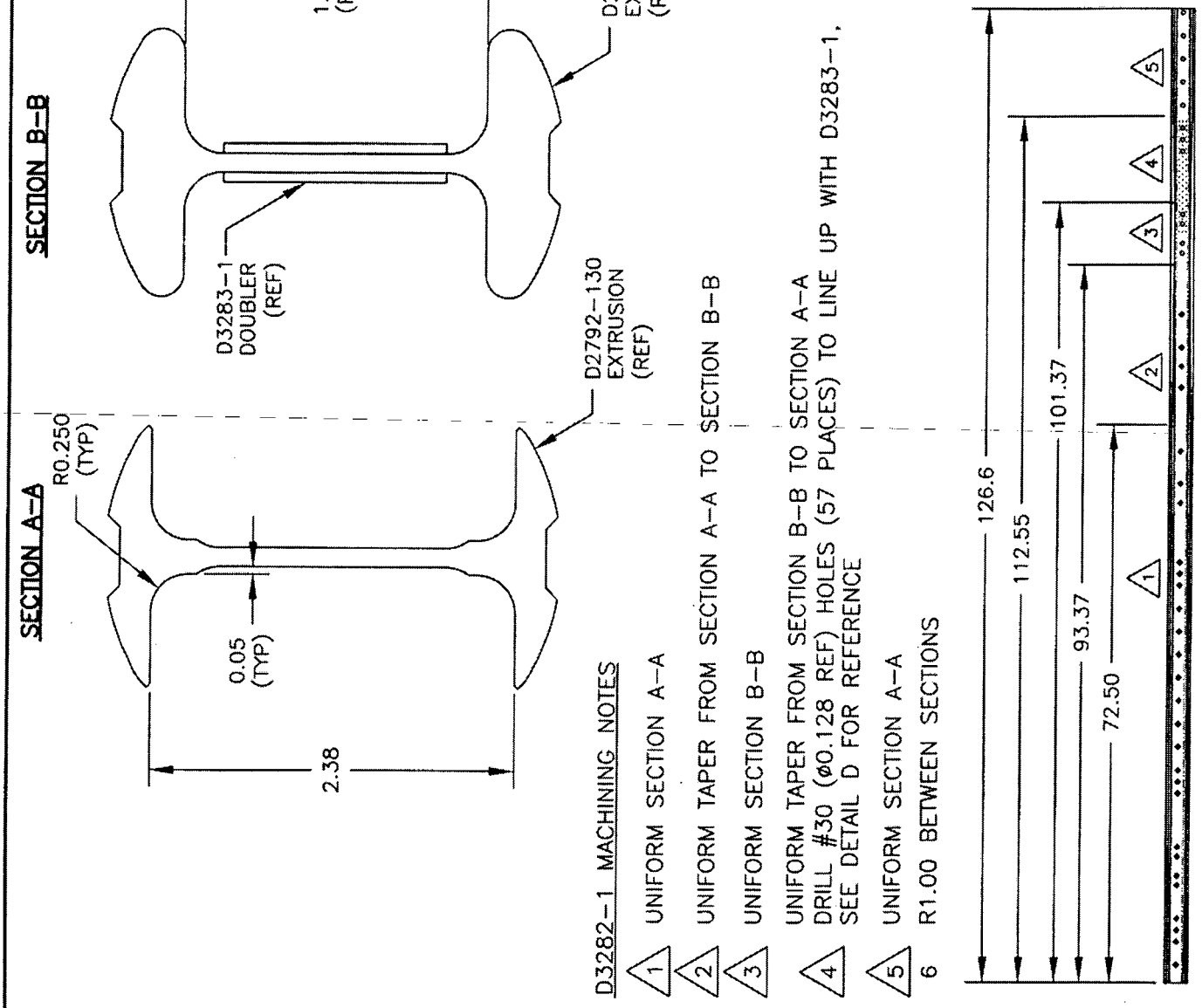
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CP	CP	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. / REV.
		D3282 / C
DATE	TITLE	SHEET 2 OF 2 / SCALE
05.08.09	FLOAT WEB, 206L/407	1:20

w/o 43389

RELEASED
05-09-12



D3282–1 MACHINING NOTES

1. UNIFORM SECTION A–A
2. UNIFORM TAPER FROM SECTION A–A TO SECTION B–B
3. UNIFORM SECTION B–B
4. UNIFORM TAPER FROM SECTION B–B TO SECTION A–A
 DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283–1,
 SEE DETAIL D FOR REFERENCE
5. UNIFORM SECTION A–A
6. R1.00 BETWEEN SECTIONS

Copyright © 2004 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries